

Date: Wednesday, 09/04/2008 9:18:27 AM
User: Julie Lecocq

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : PANEL
Job Number : 38503	
Estimate Number : 13101	
P.O. Number :	Part Number : D36551
This Issue : 09/04/2008 S.O. No. :	Drawing Number : D3655 REVA
Prsht Rev. : NC	Project Number : 00204
First Issue : / / Type : SMALL /MED FAB	Drawing Revision : A
Previous Run : 37697	Material :
Written By :	Due Date : 30/04/2008 Qty: 2 Um: Each
Checked & Approved By : <u>JTO 08.4.09</u>	
Comment : Ext. Rev. A 07/12/13	
Est Rev:B 08-03-06 prototype DD verified by:EC	
Est Rev:C 08-04-07 revA DD verified by:EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	MLEXS093F600607	GE PLASTICS LEXAN SHEET
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Comment: Qty.: 3.7134 sf(s)/Unit Total : 7.4269 sf(s)
GE PLASTICS LEXAN SHEET
batch 105494 HB 8-4-9

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET
1-Cut as per Dwg D3655
Dwg Rev: A
Prog Rev: A

HB 8-4-9



2-Deburr if necessary

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

HB 8-4-9

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

S 28/01/09 (42)

5.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1
Identify and Stock
Location: _____

P 28/4/10 (2) TABULE Fr Audit

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 09/04/2008 9:18:27 AM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PANEL

Job Number: 38503

Part Number: D36551

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



08/04/14

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-04-10

W

Dart Aerospace Ltd

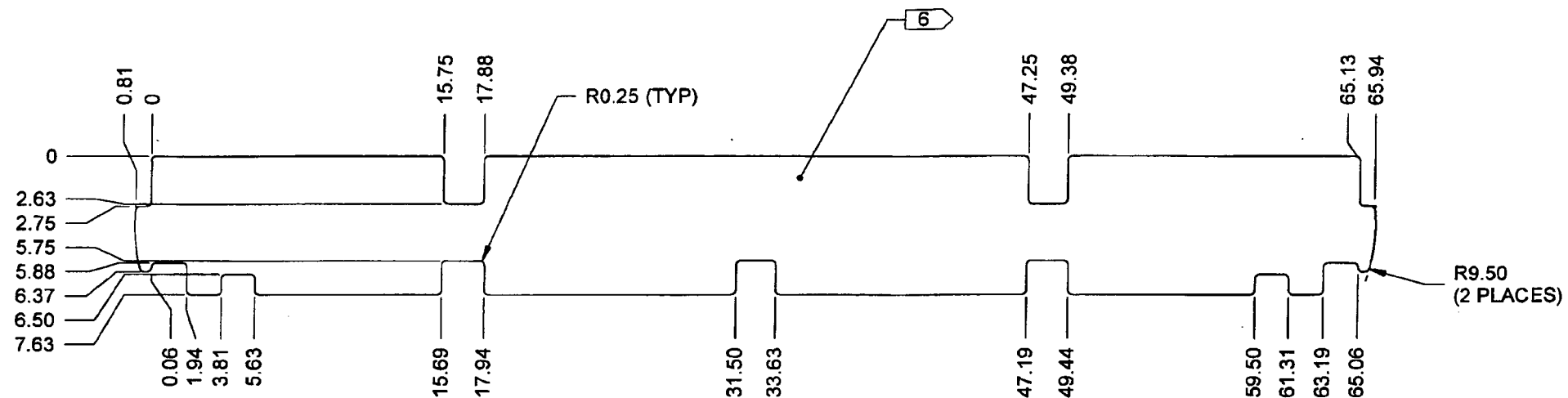
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



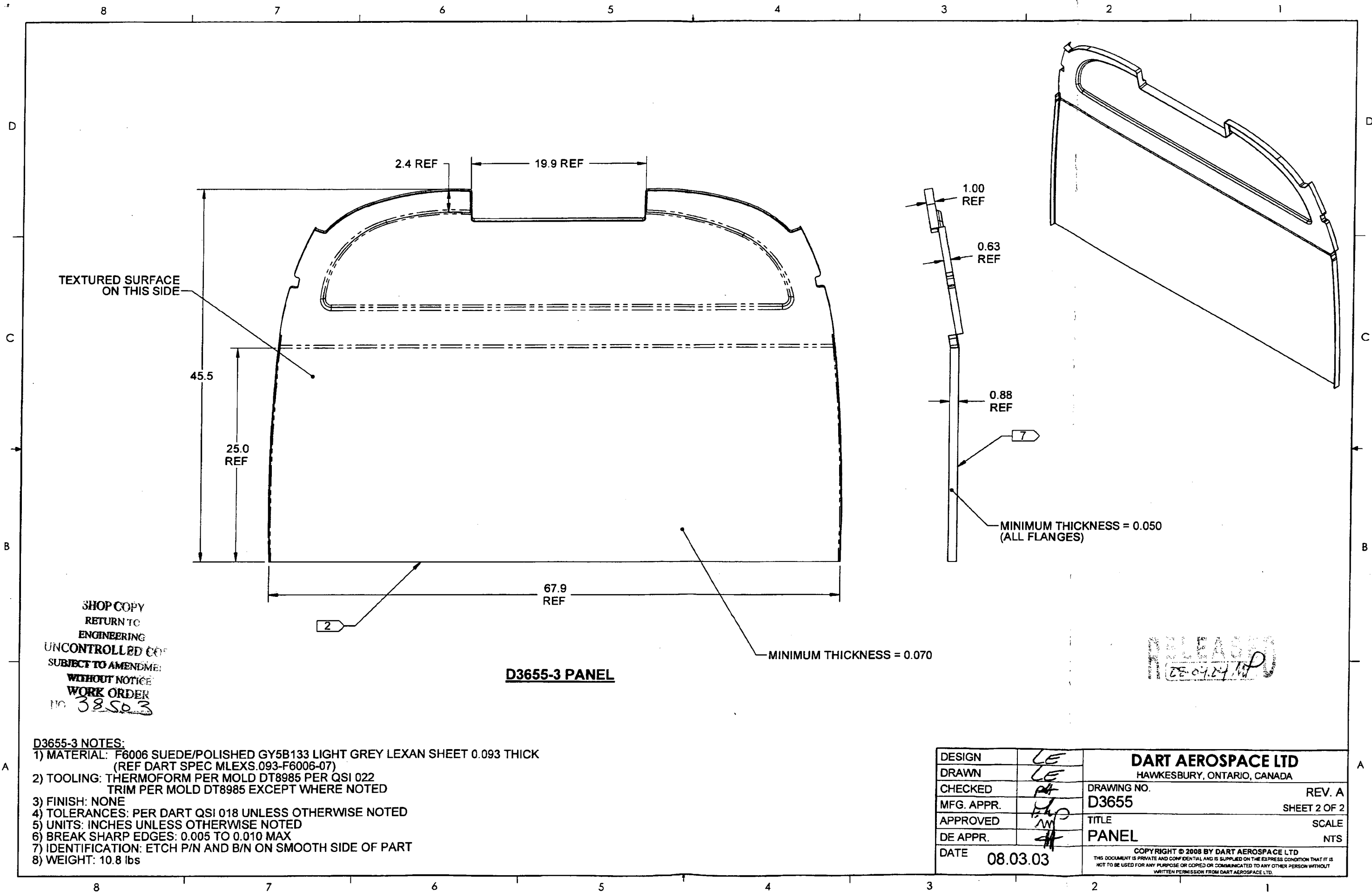
D3655-1 PANEL

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 38503

D3655-1 NOTES:

- 1) MATERIAL: F6006 SUEDE/POLISHED GY5B133 LIGHT GREY LEXAN SHEET 0.093 THICK (REF DART SPEC MLEXS.093-F6006-07)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ETCH P/N AND B/N ON SMOOTH SIDE OF PART
- 7) WEIGHT: 1.8 lbs

A	NEW ISSUE	LE	08.03.03
REV.	DESCRIPTION	BY	DATE
DESIGN	LE	DART AEROSPACE LTD	
DRAWN	LE	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RA	DRAWING NO.	REV. A
MFG. APPR.	MP	D3655	SHEET 1 OF 2
APPROVED	MP	TITLE	SCALE
DE APPR.	MP	PANEL	NTS
DATE	08.03.03	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	



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DRAWN	LE		
CHECKED	PA	DRAWING NO.	REV. A
MFG. APPR.	PA	D3655	SHEET 2 OF 2
APPROVED	PA	TITLE	SCALE
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DART AEROSPACE LTD		Work Order:	38503
Description: PANEL		Part Number:	D3655-1
Inspection Dwg: D3655-1 Rev: A		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
2.63	+/- .030	2.63	*			
2.75	+/- .030	2.75	*			
5.75	+/- .030	5.75	*			
5.88	+/- .030	5.88	*			
6.37	+/- .030	6.315	*			
6.50	+/- .030	6.502	*			
7.63	+/- .030	7.630	*			
1.94	+/- .030	1.94	*			
3.81	+/- .030	3.78	*			
5.63	+/- .030	5.60	*			
15.69	+/- .030	15.69	*			
15.75	+/- .030	15.75	*			
17.88	+/- .030	17.88	*			
17.94	+/- .030	17.94	*			
31.50	+/- .030	31.48	*			
33.63	+/- .030	33.64	*			
47.19	+/- .030	47.14	*			
47.25	+/- .030	47.25	*			
49.44	+/- .030	49.44	*			
49.38	+/- .030	49.38	*			
59.50	+/- .030	59.48	*			
61.31	+/- .030	61.31	*			
63.19	+/- .030	63.14	*			

Measured by: KB	Audited by: [Signature]	Prototype Approval: [Signature]
Date: 8-4-9	Date: 8/4/99	Date: [Signature]

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

[Signature]

